



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18538-1
Job Sheet 170431



Part No: RBT18538-1

Job Qty: 6 ea

Part Name: Left Seat Brace



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/25/18	0.00	0.00	Start Up Waterjet2		DL 18/01/17
100	Waterjet	6 pcs		1/25/18	0.00	0.60	Waterjet 2 OMAX		DL 18/01/17
110	QC	6 pcs		1/25/18	0.00	0.00	QC2 Waterjet-4		DL 18/01/17
120	QC	6 pcs		1/25/18	0.00	0.00	QC8-7		3-85
130	Brake NC	6 pcs		1/26/18	0.00	1.50	Brake NC 1		3-85
140	QC	6 pcs		1/26/18	0.00	0.00	QC5		PD. 18.02.15
150	Outsource	6 pcs		1/26/18			ATG001-VC Outsource 4		AT 18/02/18
160	Packaging	6 pcs		1/26/18	0.00	0.00	Packaging2 Outsource 4		AT 18/02/18
170	QC	6 pcs		1/26/18	0.00	0.00	QC6		3-85
180	Packaging	6 pcs		1/26/18	0.00	0.00	Packaging3-1		6 MAR 02 2018
190	QC21-SA	6 Ea		1/26/18	0.00	0.00	QC21		3-85

Part Op 100 - 1-Cut as per Dwg (RED BARN FOLDER) Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary

Descriptions: 130 - Form as per DWG sheet 2

140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - -Issue P/O to ATG: 00029091 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M5052H32S.040	2	1	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S033136



Left Seat Brace

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: RBT18538 - 1

Original Serial #: S033136

Revision:

Operation:

Change No:

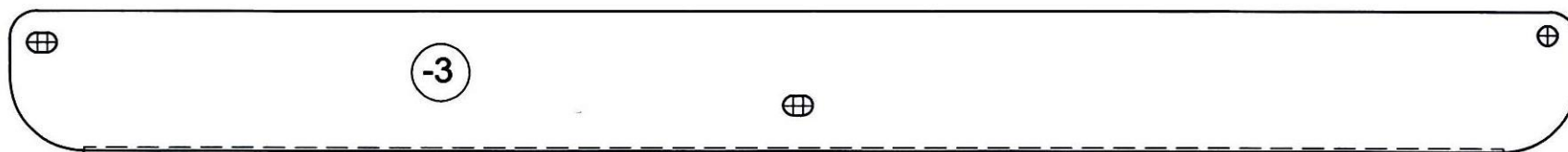
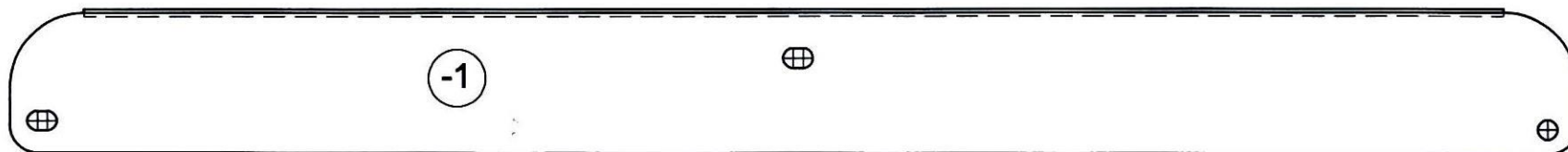
Start up Operation 01/17/18

Job No: 170431

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170431 MJS
18-01-16

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO #.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



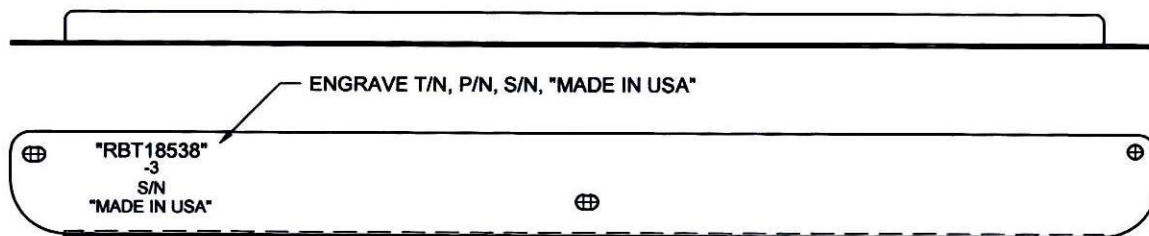
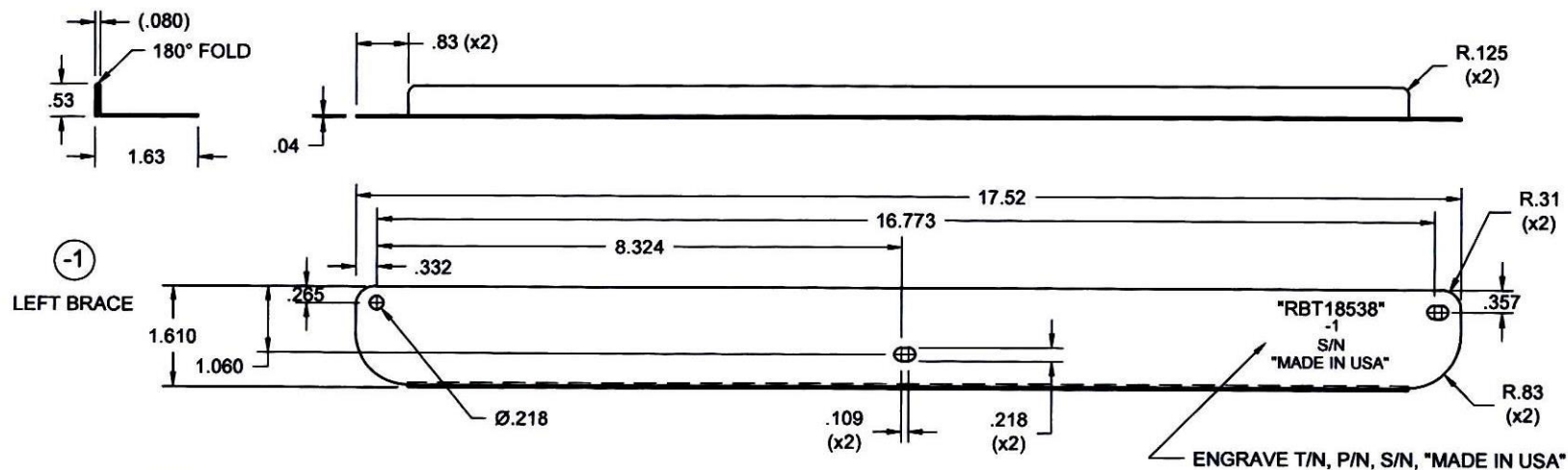
Added B & L & 407 to used on
model 3/20/12 after DW veified
the hole pattern is the same.
No rev done. RJC

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
ASSY #								

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± .5°	
METRIC REF. XXmm ± .1mm	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED: <i>D. Weir</i>	
SPEC	
USED ON MODEL BELL 206 B & L, 407	
SCALE NTS	DATE 10-7-10
SHEET 1 of 2	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO #.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



(-3)
RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXmm ± .1mm XX ± .01 FRACTIONS ± 1/32 X ± .1 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED: <i>D. M.</i> TREAT: <i>D. M.</i> FINISH: CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I USED ON MODEL: BELL 206 B & L, 407
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE: NTS DATE: 10-7-10 SHEET: 2 of 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



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Canada

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PURCHASE ORDER

PO039091

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
14	170431	RBT18538-1	required Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	3/1/18	6 pcs	0 pcs	6 pcs	\$6.25/pcs	\$37.50
15	171630	RB1741145	Indicator Test Element -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB1741145 Rev. 1 -Certificate of Conformity is required	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$5.15/pcs	\$20.60
16	170865	RB T101266-101	Blade Bolt Bullet -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant As Per Dwg RB T101266-101 Rev. 2 -Certificate of Conformity is required	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$6.25/pcs	\$25.00
Grand Total:									\$1,734.40	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/28/18 10:49 AM dart.baker.diane



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914681

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

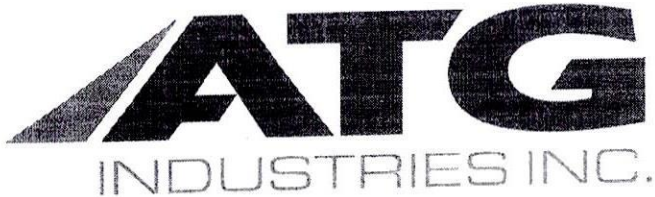
Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: RBW6405G02131-3G-3 Bell Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Seal Job: 22588		Rev: D PO: PO039091 Line: 12
6 ea	Part: RBT18538-3 Right Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22589		Rev: 2A PO: PO039091 Line: 13
6 ea	Part: RBT18538-1 Left Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22590		Rev: 2A PO: PO039091 Line: 14
4 ea	Part: RB T101266-101 Blade Bolt Bullet Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22592		Rev: 2 PO: PO039091 Line: 16
2 ea	Part: D5155-043 Co-Pilot Collective Head Assem Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Job: 22579		Rev: B PO: PO039091 Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 28/2/18 Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914681

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Certified Signature: <u><i>Yves Richer</i></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		